

**Aero Design Ltd.****Work Order Control Sheet****Work Order#:** 2015-21 **Date Opened:** 25 Feb 2015 **Title:** Assembly**Aircraft OEM:** Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Cargo Basket **Product Model:** Long **Quantity:** 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

JR

N/A

JR

JR

N/A

JR

N/A

N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JR

JR

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
78410	2	Basket Assembly	JR
78427	2	Placard	JR

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1

N/A

N/A

N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JR

N/A

N/A

N/A

N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A

N/A

N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JR

N/A

N/A

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

MR

MR

MR

MR

MR

MR

MR

Work performed by:

Print: J Rekve for M Rekve

ICC / Dual Inspection performed by:

Print: Jason Rekve

Work Order closed by:

Print: Jason Rekve

Approved Manufacturing Facility 73-04

Sign:

Sign:

Sign:

Form 20.D.03

SCA: AD01

SCA: AD01

SCA: AD01

Date: 25-Feb-15

Date: 25-Feb-15

Date: 01-Mar-15

Rev. Original 23 Sep 2014

## **CARGO BASKET ASSEMBLY - COMMON**

AS350 Long

### **General**

Wo 2015-21

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69810, Revision 3 – Standard Low Mounted Basket  
94510, Revision 0 – Extra-Wide Low Mounted Basket  
94610, Revision 0 – Extra-Wide Low Mounted Ski Basket  
76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77610, Revision 1 – Short Basket  
76410, Revision 3 – Medium Basket (left or right)  
78410, Revision 2 – Long Basket  
94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80210, Revision 0 – Short Basket  
80310, Revision 0 – Medium Basket  
81110, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95911, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75111, Revision 0 – Standard Basket  
95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options**

70405, Revision 3? – Lid Walkway

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: \_\_\_\_\_

Date Open: \_\_\_\_\_

AD06

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

### 2. Body Assembly

AD06

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??



- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

## 3. Hinge Installation

A000

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

## 4. Install Handle

ADD

- a. Install handle brackets.
  - i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
  - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
  - iii. Torque AN3 bolts to ??.
- b. Install handle
  - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
  - ii. Grease two 36275-01 bushings with ?? . Insert into bushings of handle assembly.
  - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
  - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
  - v. At first end, remove bolt and repeat step iv.
  - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
  - vii. Torque AN3 bolts to ??.
- c. Check handle
  - i. Operate handle to ensure handle does not bind and springs hold handle in.
  - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

## 5. Install lid brace

ADD

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

OK

### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.



Work Order: 2015-71Date Opened: 25 FEB 2015Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		78410-01	<b>Cargo Basket Assembly</b>		
<b>Step 1</b>				<i>Lid Assembly</i>		
	1		78412-01	Basket Lid Assembly		2015-18
Step 1.a.	4		49205-14	Bumper	Argus Industries Bumper	11610
	A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	1		78427-01	Placard	0.063 Sheet, 6061-T6 Aluminum	78401-555V
	4		CR3213-4-02	Cherry Rivet		14097
Step 1.c.	1		70405-01	Lid Step Modification		
(option)	1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	14074
	A/R		CR3213-4-02	Cherry Rivet		14097
	A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	1		78411-01	Basket Body Assembly		2015-17
	4		96710-01	Fitting	Alternate: Ancra 40088-14	1415006
	8		NAS1149F0663P	Washer		14048
<b>Step 3</b>				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	90"	14091
	8		CR3523-5-02	Cherry Rivet		14090
	A/R		CR3213-5-02	Cherry Rivet		14094
<b>Step 4</b>	1		84255-01	<i>Handle Installation</i>		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	2015-02
	4		AN3-11A	Bolt		14068
	8		NAS1149F0363P	Washer		14072
	4		MS21044N3	Nut		14072

Work Order: 2015-21Date Opened: 25 FEB 2015Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	. . 1		84261-01	Handle Assembly		
	. . 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	. . 2		36275-01	Bushing	Brass, 5/16" Dia	Not INSTALLED
	. . 2		AN3-12A	Bolt		
	. . 4		NAS1149F0363P	Washer		
	. . 2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				Inspection	None	



2015-21

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG	BJC	27/01/2010
2	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

## NOTES

1. ENGRAVE 0.007 DEEP AS FOLLOWS:  
 "QUICK RELEASE BASKET" - 0.125 HIGH  
 "EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH  
 "S/N 78401-XX" - 0.080 HIGH  
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
 "250 LBS/113 KG" - 0.200 HIGH  
 "AERO DESIGN LTD." - 0.125 HIGH  
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH  
 "www.aerodesign.ca" - 0.080 HIGH


DRILL #30 (0.129)  
4 PLACES



01 PLACARD

78427-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

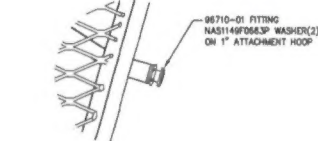
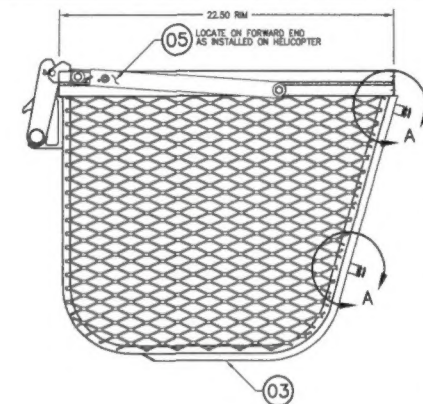
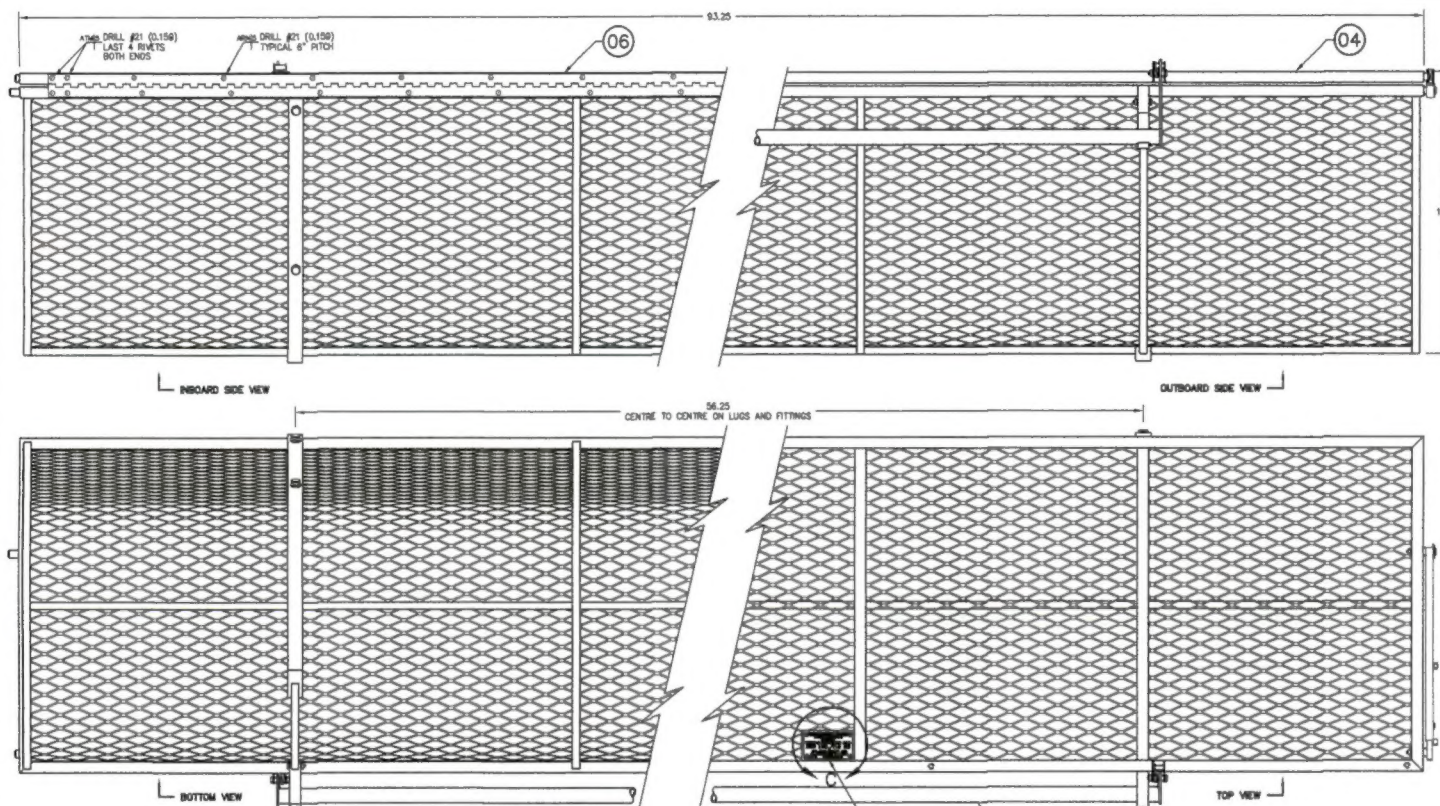
## LIST OF MATERIALS

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.	APPROVALS		DATE			<b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2376      www.aerodesign.ca				
	DRAWN: R. RATHWELL		18 FEB 08							
	CHECKED: E. BURGAIN									
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX    ±0.010                      ±1/2" X.XX     ±0.03 X.X      ±0.1					EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD				
					SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.		
					SHEET 1 OF 1	A4	78427	2		



8015-21

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE CONFIGURATION, REMOVED ALTERNATE BASKET	B.J.C.	27/01/2010
2	UPDATE TITLE BLOCK, ADD ALTERNATE RIVETS, HARDWARE P/N'S UPDATED, HINGE LENGTH, CHANGE BRACE ASSEMBLY TO INSTALLATION	B.J.C.	10/07/2014



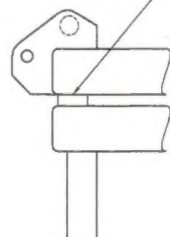
DETAIL A

SCALE 1 : 2  
TYPICAL UPPER AND LOWER, FRONT AND REAR

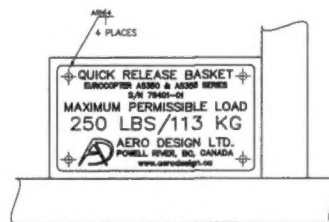
NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

01 CARGO BASKET ASSEMBLY

FILL 1/4" HOLE WITH COMMERCIAL SILICONE SEALANT  
INSERT BUMPER INTO HOLE  
4 PLACES




BUMPER INSTALLATION  
SCALE 1 : 1



DETAIL C

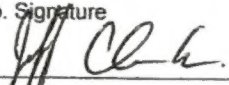
SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

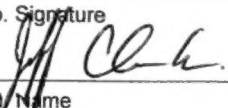
A/R	NAS1149/D663P	WASHER				
	06710-01	FITTING		ALTERNATE: ANORA 4000B-14		
B	CR3523-5-02	CHERRY RIVET		ALTERNATE: HUXMAX HR3523-5-02		
A/R	CR3213-5-02	CHERRY RIVET		ALTERNATE: HUXMAX HR3213-5-02		
	CR3213-4-02	CHERRY RIVET		ALTERNATE: HUXMAX HR3213-4-02		
	49205-14	06 BUMPER		ARGUS INDUSTRIES		
1	78427-01	08 PLACARD				
1	84235-01	07 HANDLE BAR INSTALLATION				
A/R	MS20001P4	06 PLANO HINGE			90.5 LONG	
1	84240-01	05 LID BRACE INSTALLATION				
1	78412-01	04 LID ASSEMBLY				
1	78411-01	03 BASKET BODY ASSEMBLY				
		02				
1	78410-01	01 CARGO BASKET ASSEMBLY				
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY						

BASIC CODE		DASH NO. FOR DIAMETER		APPROVALS		DATE	
REF: NAS 523		N=MFD. HEAD NEAR SIDE		DRAWN: R. RATHWELL		19 FEB 08	
C=COUNTERSINK		F=MFD. HEAD FAR SIDE		CHECKED: E. BURGOIN		<div><div>AERO DESIGN LTD. 9808A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G5 TEL: 604.685.2978 www.aerodesign.ca</div><div>EUROCOPTER AS350 &amp; AS355 SERIES QUICK RELEASE SKI BASKET BASKET ASSEMBLY (LONG)</div><div>SCALE 1 : 4</div><div>SHEET 1 OF 1</div><div>A1784102</div></div>	
D=DIMPLE		DASH NO. FOR LENGTH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
DIGIT# OF SHEETS				DECIMALS ANGLES			
TO BE DIMPLED				X.XXX ±0.010 ±1/2°			
BASIC CODES:				X.XX ±0.03			
BU=MS20470AD				X.X ±0.1			
AR=CR3213							
ATM=CR3523							
+ INSTALL NEW RIVET							
+ REMOVE/REPLACE RIVET							
- EXISTING RIVET							

[illegible]



Issuing Civil Aviation Authority/Country <b>Transport Canada</b>		<b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.
Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO2015-21</b>
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	<b>Long Cargo Basket</b>	<b>78410-01</b>	<b>1</b>	<b>78401-55</b>	<b>New</b>
12. Remarks <b>Modified with walkway on lid IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the <del>Canadian Aviation Regulations</del> .		
13b. Signature	13c. Approved Organization Number		14b. Signature	14c. Approved Organization Number	
	<b>AMF 73-04</b>				
13d. Name	13e. Date (dd/mmm/yyyy)		14d. Name	14e. Date (dd/mmm/yyyy)	
<b>Jeff Clarke - AD02</b>	<b>25 Feb 2015</b>				
<b>Installer Responsibilities</b>					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO2015-21	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Long Cargo Basket	78410-01	1	78401-55	New	
12. Remarks Modified with walkway on lid IAW DCL704						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 25 Feb 2015		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

AIRSPAN